Dart Aerospace Ltd.

Date: Monday, 6/5/2006 7:47:29 AM
User: Kim Johnsten

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: BRACKET ASSEMBLY
Job Number	: 27369		
Estimate Number	: 10279		
P.O. Number	: N/A	**Part Number**	: D3121143
This Issue	: 6/5/2006 **S.O. No.** : N/A	**Drawing Number**	: D3121 REV C2
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: N/A **Type** : MACHINED PARTS	**Drawing Revision**	: C2
Previous Run	: 26038	**Material**	: N/A
Written By	: KJ 06/06/05	**Due Date**	: 6/30/2006 **Qty:** 4 **Um:** Each
Checked & Approved By	:		
Comment	: Est Rev:Pick:A 04.02.18 New issue KJ/DS		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	M174B1000X02000	17-4 SS Bar

Comment: Qty.: 0.3864 f(s)/Unit Total : 1.5456 f(s)
Material: 17-4 SS Bar per AMS 5604/5643
(M17-4-B1.000x02.000)
Identify for D3121-113
Batch: M19478 J.L 06/07/23

2.0	BAND SAW	BAND SAW

Comment: BAND SAW
Cut blanks: (1.000" x 2.000") 4.425" long J.L 06/07/23

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1

Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine D3121-113 as per Folio FA330 and Dwg D3121
Identify as D3121-113

2-Deburr

3-Scribe batch number J.L 06/07/23

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE JL 06/07/25

Form: rprocess

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Mfg / Design Mgr	**Approval** QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Design Mgr	**Approval** QC Inspector
			Initial Design Mgr	**Action Description** Design Mgr	**Sign & Date**			

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes (No) **DQA:** _____ **Date:** 04/09/14

NOTE: Date & initial all entries **QA: N/C Closed:** _____ **Date:** _____

Date: Monday, 6/5/2006 7:47:30 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** BRACKET ASSEMBLY

Job Number: 27369 **Part Number:** D3121143

Job Number:

Seq. #:	Machine Or Operation:	Description :
5.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	MS 06/07/23 4
6.0	D312121	Bolt
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s) Pick: Qty Part Number Description Batch 2 D3121-21 Bolt B27412	J.G 06/09/07 4
7.0	D3121241	Bearing Assembly
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s) Pick: Qty Part Number Description Batch 2 D3121-241 Bearing Ass B 27433	J.G 06/09/07 4
8.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
	Comment: SMALL & MEDIUM FAB RESOURCE 1 Assemble D3121-143 as per Dwg D3121.	J.G 06/09/07 4
9.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	06/09/07 4
10.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location: ST408	6/9/8 (4)
11.0	DC	DOCUMENT CONTROL
	Comment: DOCUMENT CONTROL Inspection Level 21	(4) 06/09/11

Job Completion

11 26.09.11

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Mfg / Design Mgr	**Approval** QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Design Mgr	**Approval** QC Inspector
			Initial Design Mgr	**Action Description** Design Mgr	**Sign & Date**			

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ **Date:** _____

DART AEROSPACE LTD	Work Order:	27369
Description: Bracket	Part Number:	D3121-113
Inspection Dwg: D3121 **Rev:** C2		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.080	+/-0.010	.079	✓			
0.300	+/-0.010	.300	✓			
R0.375	+/-0.010	.375	✓			
1.54	+/-0.030	1.539	✓			
0.350	+/-0.010	.350	✓			
R0.250	+/-0.010	.250	✓			
1.800	+/-0.030	1.799	✓			
Ø0.392	+0.002/-0.000	.392	✓			
Ø0.201	+0.005/-0.000	.201	✓			
0.100	+/-0.010	.100	✓			
2.540	+/-0.010	2.539	✓			
1.590	+/-0.010	1.590	✓			
0.160	+/-0.010	.160	✓			
0.400	+/-0.010	.399	✓			
1.220	+/-0.010	1.219	✓			
1.600	+/-0.010	1.601	✓			
3.80	+/-0.030	3.800	✓			
1.800	+/-0.010	1.801	✓			
R0.500	+/-0.010	.500	✓			
0.130	+/-0.010	.131	✓			
3.41	+/-0.030	3.390	✓			
3.65	+/-0.030	3.650	✓			
2.24	+/-0.030	2.230	✓			
45°	+/-0.1°	45°	✓			
R0.250	+/-0.010	.250	✓			
3.97	+/-0.030	3.968	✓			
R0.38	+/-0.030	.380	✓			
Ø0.392	+0.002/-0.000	.392	✓			
Ø0.201	+0.005/-0.000	.201	✓			
0.100	+/-0.010	.099	✓			
0.268	+/-0.010	.267	✓			
R0.260	+/-0.010	.260	✓			
0.080	+/-0.010	.078	✓			
0.300	+/-0.010	.300	✓			

DART AEROSPACE LTD	Work Order:	27369
Description: Bracket	Part Number:	D3121-113
Inspection Dwg: D3121 **Rev:** C2		Page 2 of 2

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.381	+/-0.010	.385	✓			
0.201	+/-0.010	.202	✓			
0.580	+/-0.010	.583	✓			
0.400	+/-0.010	.399				
			✓			
100°	+/-0.1°	100°				
~~.032 0.32~~	+/-0.010	.030	✓			

Measured by:	J.L
Date:	06/07/23

Audited by:	[illegible]
Date:	06/07/23

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.12.08	New Issue P/O D3121-143	KJ/RF	
B	04.05.05	Dimensions changed/re-arranged per Dwg revision	KJ/JLM	

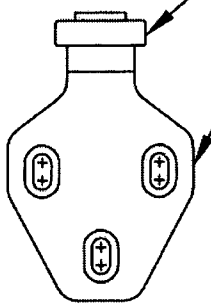
DART

QA COPY ISSUED

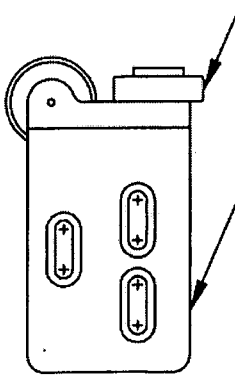
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3121 REV. C SHEET 1 OF 10
DATE 04.02.17		TITLE BRACKET ASSEMBLY SCALE 1:2

A	02.04.15	NEW ISSUE
B	03.01.16	ADD RIDGES; ADD MAT'L PROP; FIX P/N ADD -141/-143/-144/-145/-146
C	04.02.17	ADD CLEARANCE; USE -241 BEARING
C1	04.03.26	3.97 WAS 4.00; 6.11 WAS 6.14
C2	04.04.26	0.230 WAS 0.238

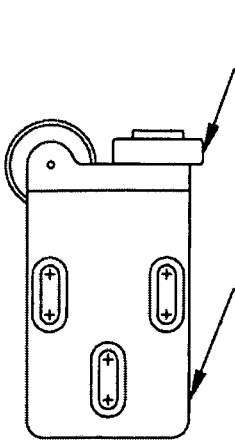
RELEASED
04.03.01



D3121-041 BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-33)



D3121-043 (SHOWN) / D3121-044 (OPPOSITE) BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-37/-38)



D3121-045 (SHOWN) / D3121-046 (OPPOSITE) BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-35/-36)

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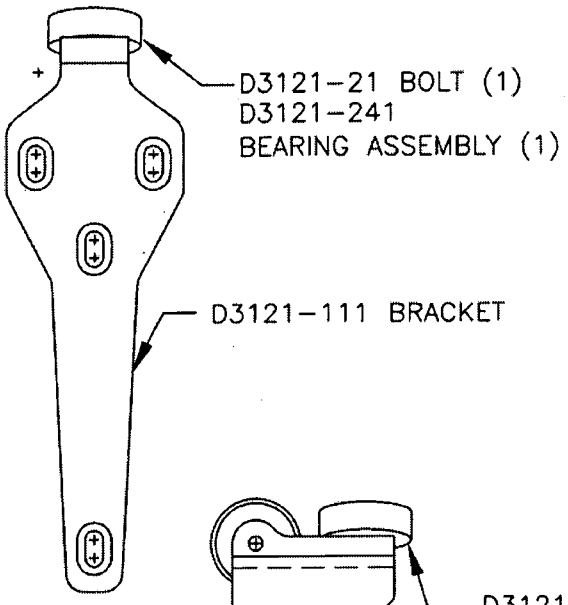
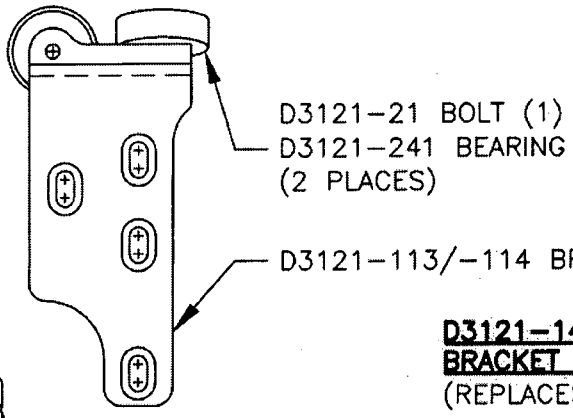
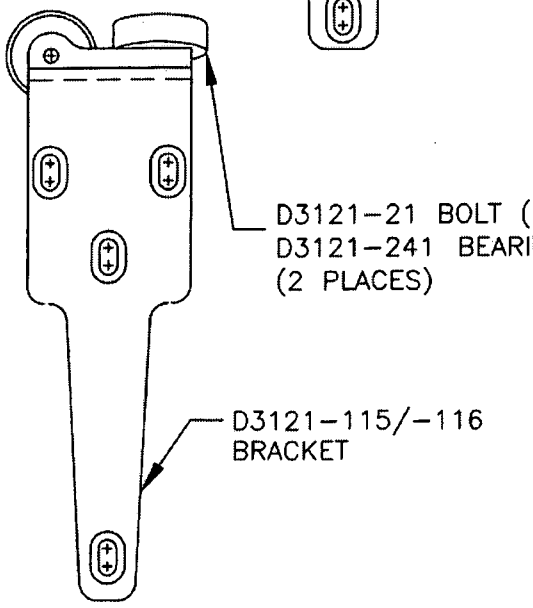
DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:2



D3121-141 BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23001-01)



D3121-143 (SHOWN) / D3121-144 (OPPOSITE) BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-03/-04)



D3121-145 (SHOWN) / D3121-146 (OPPOSITE) BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-05/-06)

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DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:1

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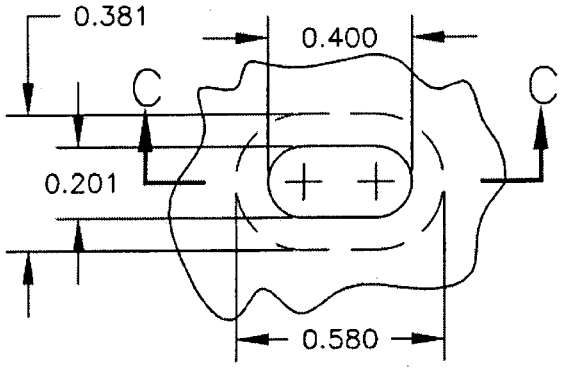
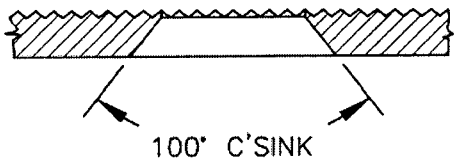
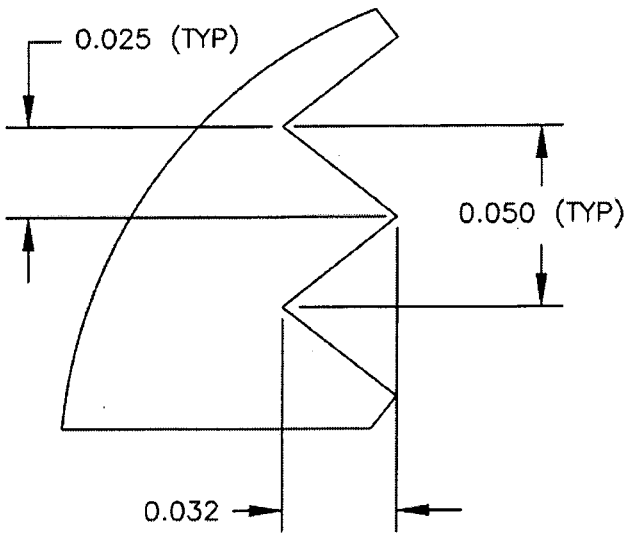
DETAIL A:
SLOT DETAIL
SCALE 2:1
VIEW ROTATED





SECTION C–C

DETAIL B:
RIDGE DETAIL
PARTIAL SECTION
SCALE 1:20



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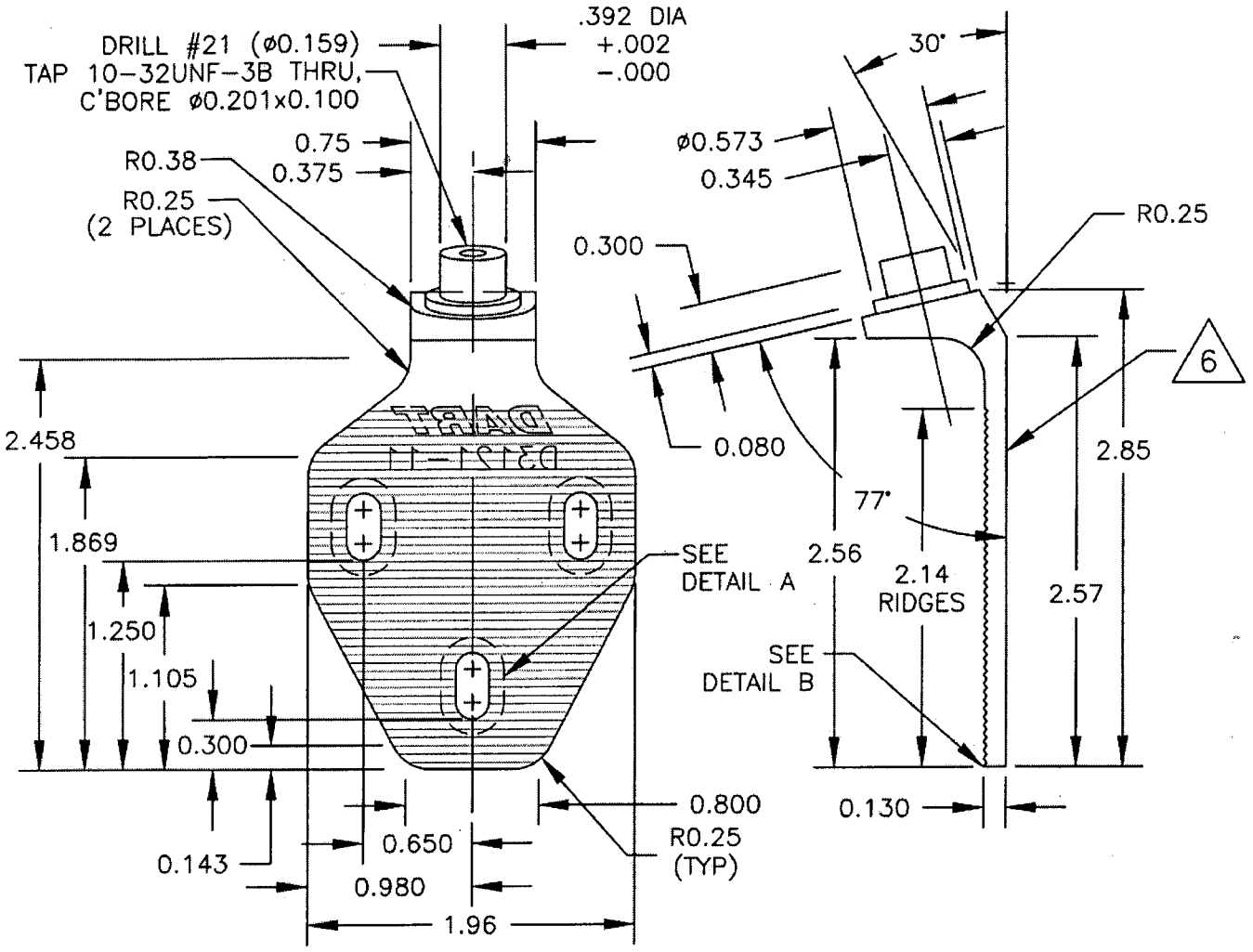
CHECKED	APPROVED	DRAWING NO. D3121	REV. C SHEET 4 OF 10
DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:1



D3121-11 BRACKET

1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
   MIN ULTIMATE TENSILE = 150 ksi
   MIN YIELD TENSILE = 100 ksi
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.015
5) ENGRAVE DART P/N & LOGO AS SHOWN
6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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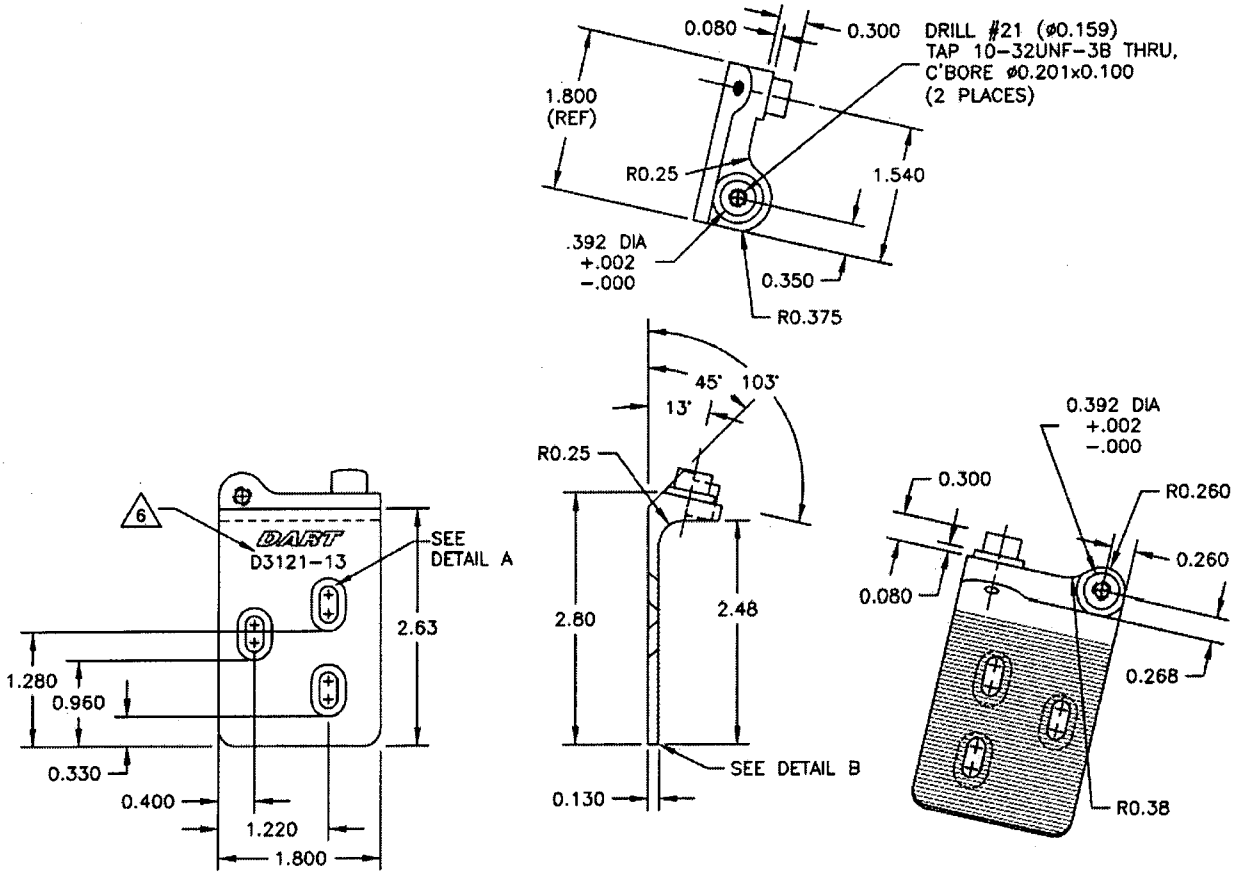
CHECKED	APPROVED	DRAWING NO. D3121	REV. C SHEET 5 OF 10
DATE 04.02.18		TITLE BRACKET ASSEMBLY	SCALE 1:2



D3121-13 BRACKET (SHOWN)
D3121-14 BRACKET (OPPOSITE)

1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
   MIN ULTIMATE TENSILE STRENGTH = 150 ksi
   MIN YIELD TENSILE STRENGTH = 100 ksi
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.015
5) ENGRAVE DART P/N & LOGO AS SHOWN
6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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DATE 04.02.18		TITLE BRACKET ASSEMBLY	SCALE 1:2

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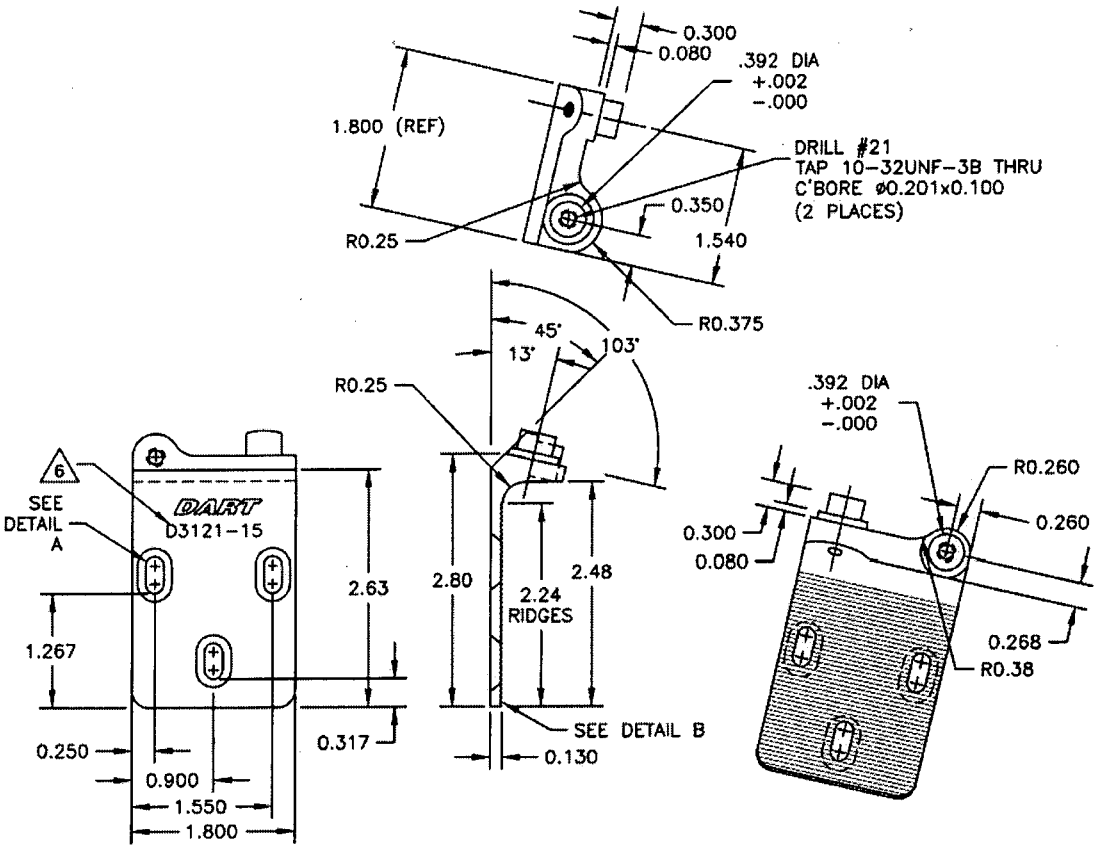

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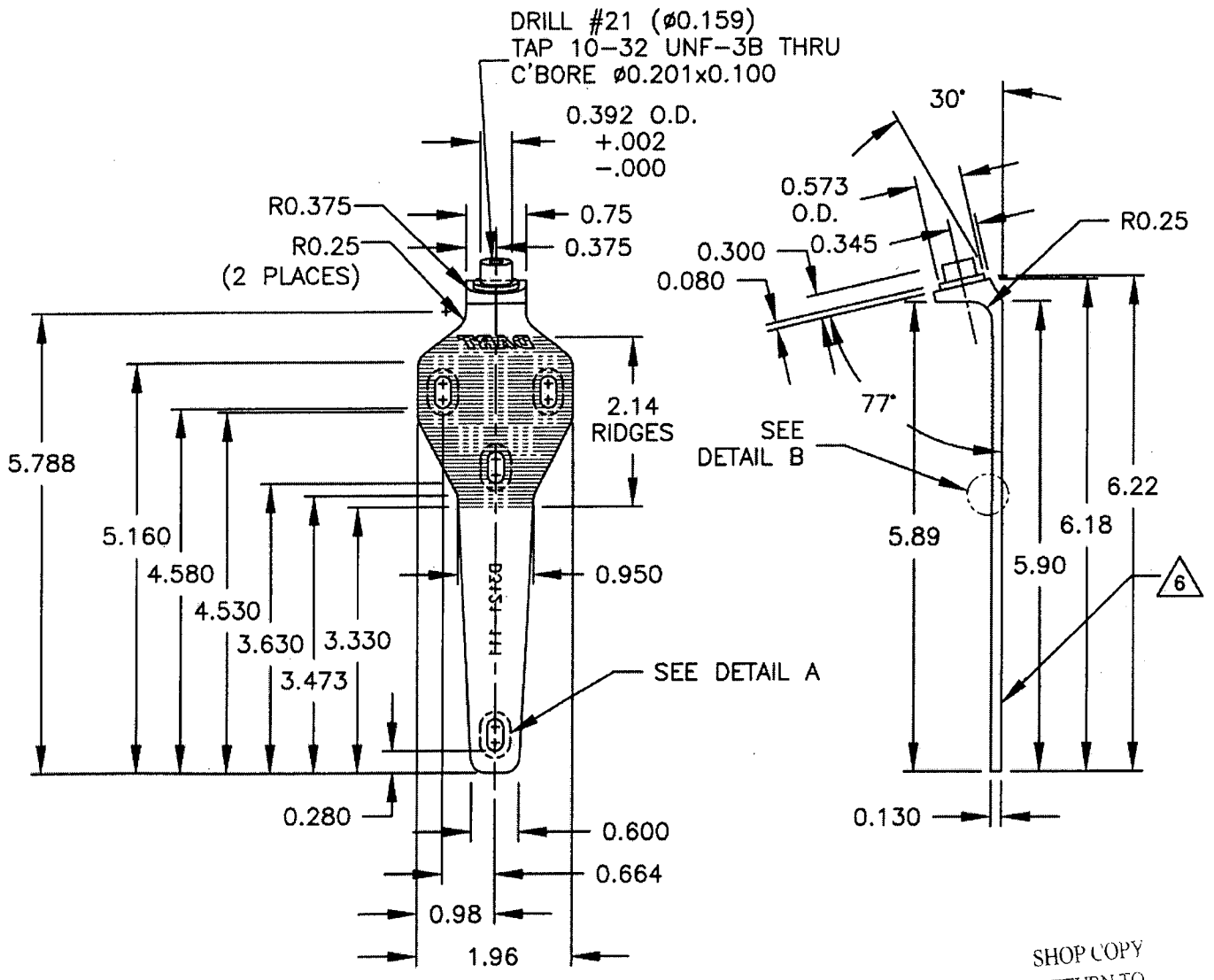
D3121−15 BRACKET (SHOWN)
D3121−16 BRACKET (OPPOSITE)

1) MATERIAL: 17−4 SS PER AMS 5604/5643 (REF DART SPEC. M17−4−B)
   MIN ULTIMATE TENSILE = 150 ksi
   MIN YIELD TENSILE = 100 ksi
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.015
5) ENGRAVE DART P/N AND LOGO AS SHOWN
6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

RELEASED
04.03.01

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3121	REV. C SHEET 7 OF 10
DATE 04.02.18		TITLE BRACKET ASSEMBLY	SCALE 1:2



D3121-111 BRACKET

1) REPLACES PREMIER P/N B32-23001-11
2) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
   MIN ULTIMATE TENSILE = 150 ksi
   MIN YIELD TENSILE = 100 ksi
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHEWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.015
6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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CHECKED	APPROVED	DRAWING NO. D3121	REV. C SHEET 8 OF 10
DATE 04.02.18		TITLE BRACKET ASSEMBLY	SCALE 1:2

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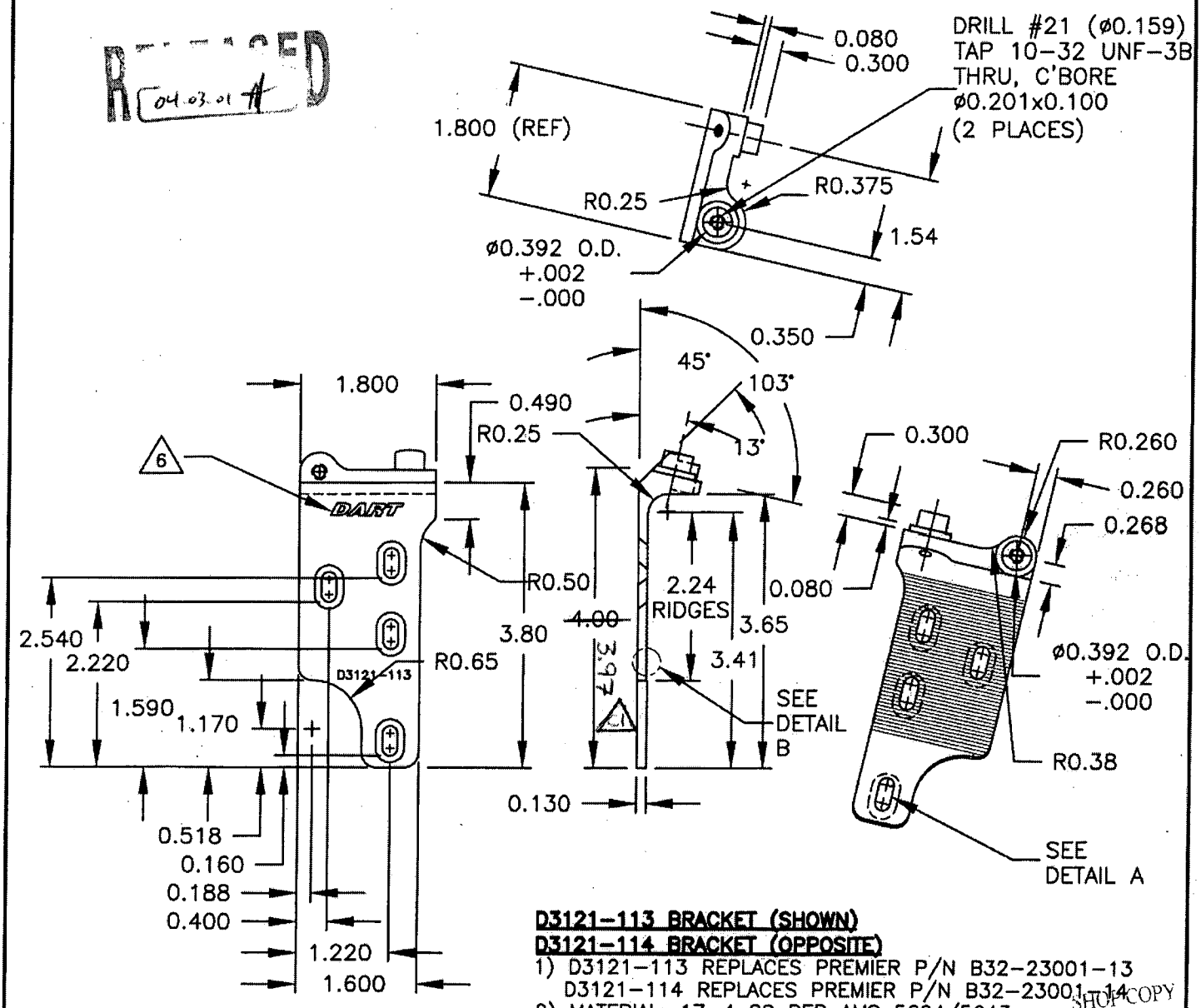

D3121-113 BRACKET (SHOWN)
D3121-114 BRACKET (OPPOSITE)

1) D3121-113 REPLACES PREMIER P/N B32-23001-13
   D3121-114 REPLACES PREMIER P/N B32-23001-14
2) MATERIAL: 17-4 SS PER AMS 5604/5643
   (REF DART SPEC. M17-4-B)
   MIN ULTIMATE TENSILE STRENGTH = 150 ksi
   MIN YIELD TENSILE STRENGTH = 100 ksi
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.015
6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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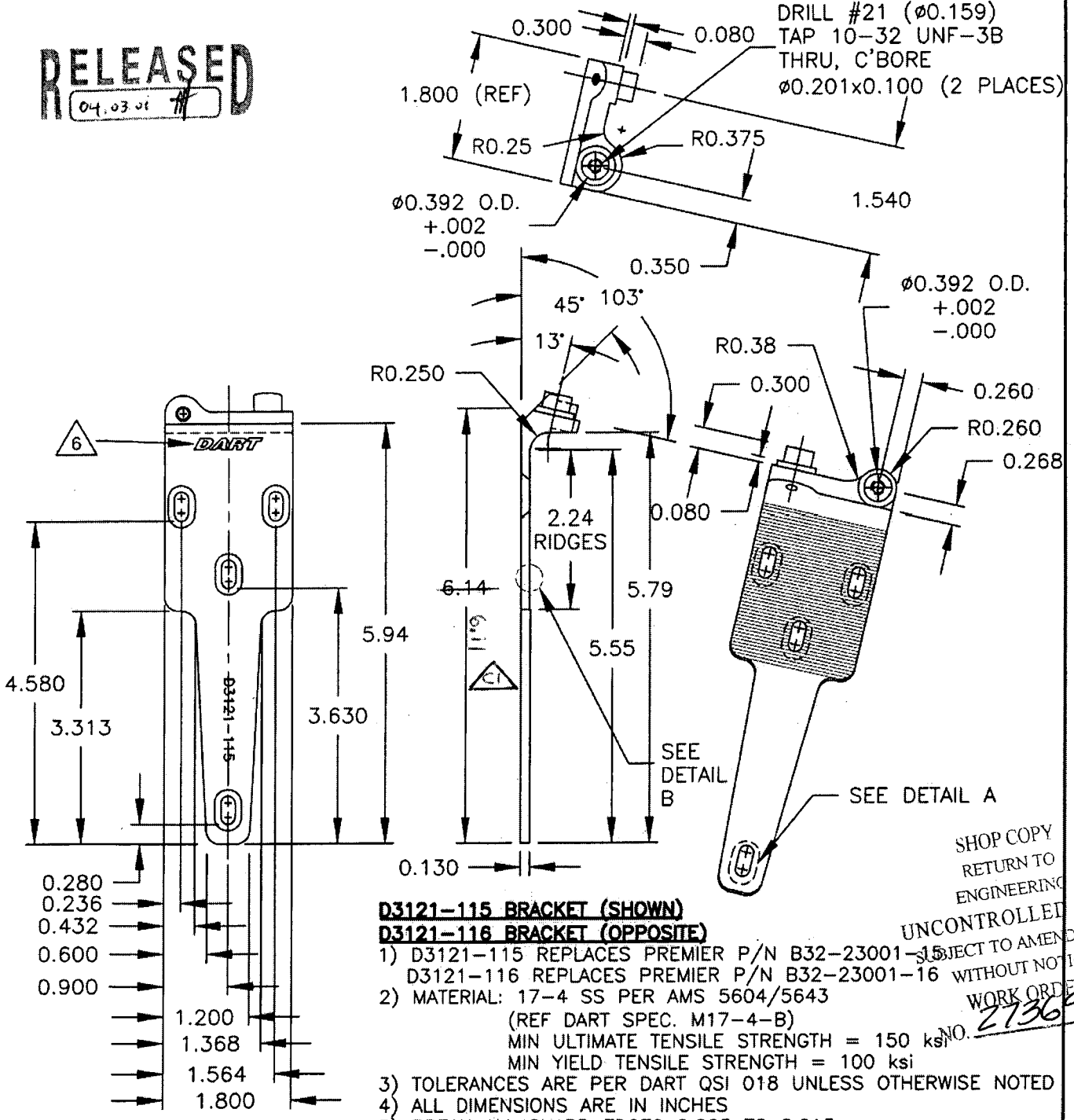
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3121	REV. C SHEET 9 OF 10
DATE 04.02.18		TITLE BRACKET ASSEMBLY	SCALE 1:2

RELEASED
04.03.01



D3121-115 BRACKET (SHOWN)
D3121-116 BRACKET (OPPOSITE)

1) D3121-115 REPLACES PREMIER P/N B32-23001-15
   D3121-116 REPLACES PREMIER P/N B32-23001-16
2) MATERIAL: 17-4 SS PER AMS 5604/5643
   (REF DART SPEC. M17-4-B)
   MIN ULTIMATE TENSILE STRENGTH = 150 ksi
   MIN YIELD TENSILE STRENGTH = 100 ksi
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.015
6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3121	REV. C SHEET 10 OF 10
DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:1

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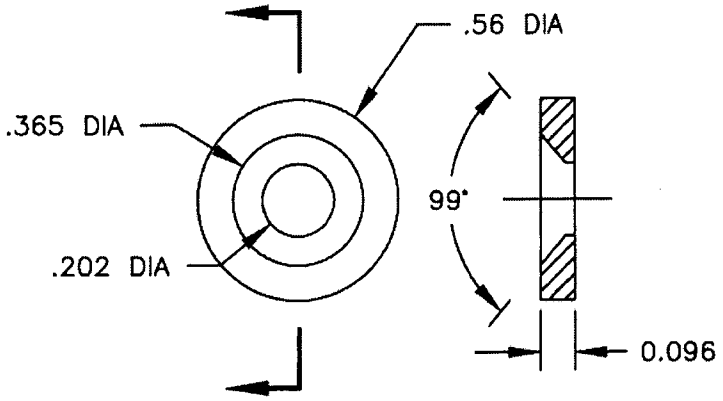
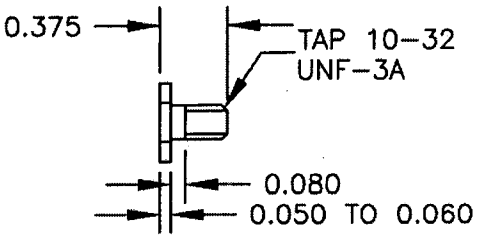


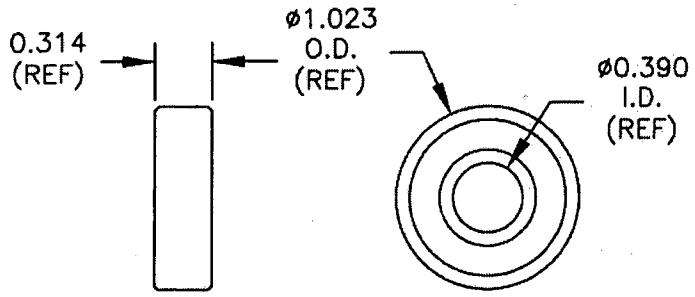
D3121-17 WASHER (SCALE 2:1)

1) REPLACES PREMIER P/N B32-23001-17
2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.015



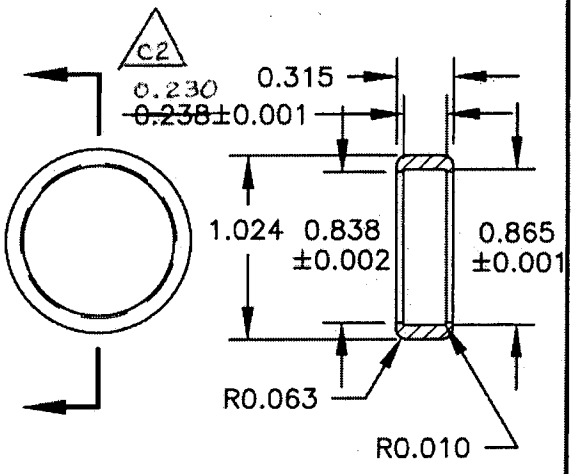
D3121-21 BOLT (SCALE 1:1)

1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.015



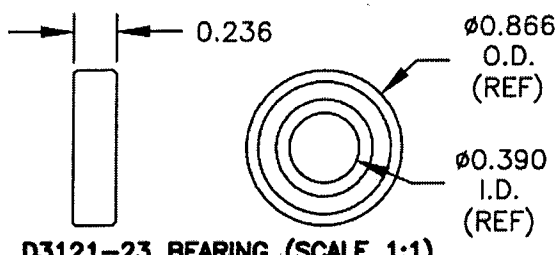
D3121-19 BEARING (SCALE 1:1)

1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM
FAFNIR P/N 9100KDD
2) ALL DIMENSIONS ARE IN INCHES



D3121-25 CAP (SCALE 1:1)

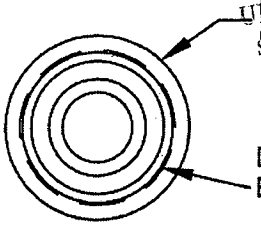
1) MATERIAL: DELRIN ROD, ø1.25
(REF DART SPEC. M-DELRIN-R1.250)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES



D3121-23 BEARING (SCALE 1:1)

1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z
OR KML P/N 6900-ZZ
2) ALL DIMENSIONS ARE IN INCHES

RELEASED
04.03.01



D3121-241 BEARING ASSEBLY (SCALE 1:1)

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